

Work Order ID 151552

Tuesday, September 27, 2016 2:32:27 PM

151552

Page 1

Item ID: D4775-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut Assembly

Start Date: 9/23/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 9/27/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

DAS

Date:

SEP 28 2016

Tooling:

Date:

Run Start ***NR1***

QC:

21

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4775	C

110	Pick Kit	0.00
-----	----------	------

110

Packaging

Memo

0.00

Packaging

120

0.00

120

Small Fab

Memo

0.16

Small Fab

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH:

135390

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

8X
DAS
6
9-89**OCT 18 2016****8**
FF**OCT 20 2016**

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Page 2

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Strut Assembly
Start Date: 9/23/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 9/27/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				<u>8</u>			DAS 38 9-29 OCT 20 2016
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>St357</u> Memo	0.00 0.01				<u>8</u>			OCT 21 2016 DAS 21 9-29
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.08							DAS 21 9-29 OCT 21 2016 VS 16/10/21 DAS 21 9-29

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Work Order ID: 151552

151552

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 9/23/2016

Required Date: 9/27/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
REV:B 13.08.26 PB1 DD VERF:JLM IPP REV:C
13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10
AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1 *D4775-1* Strut Tube		Manufactured	No			110	Each	20.0000	1	5.8 151552 x 7		OCT 1 8 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST357				20					
				146077				2					
				147995				18		1			
D4777-1 *D4777-1* Rod End Bearing		Manufactured	No			110	Each	22.0000	1	5.8 151287 x 4		OCT 1 8 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST125				22					
				147062				11					
				149661				5					
				150859				6		4			
D4776-1 *D4776-1* Basket Strut Clevis		Manufactured	No			110	Each	18.0000	1	5.8 151052		OCT 1 8 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST124				18					
				147628				8					
				149653				10					

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID: 151552

151552

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 9/23/2016

Required Date: 9/27/2016

Start Qty: 5.00

Required Qty: 5.00

D4776-5

Manufactured No

110

Each

80.0000

4

D4776-5

Spacer

**

Location

Loc Qty

Loc Code

ST125

80

143498

1

146132

17

148217

22

149692

40

AN3-10A

Purchased

No

110

Each

211.0000

2

AN3-10A

Bolt

**

Location

Loc Qty

Loc Code

GA

2

m132763

1

m134573

1

over003

100

m135530

100

ST349

109

m134249

56

m134754

6

m134943

44

m135135

3

2032
157558 x 20
157812 x 5

DAS
6
OCT 18 2016

7
10 56

AS
OCT 18 2016
3
-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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151552

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 9/23/2016

Required Date: 9/27/2016

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

110

Each

2,139.000

2

10 16

MS21042L3

Nut

**

DAS
6
9-89

OCT 1 8 2016

Location

Loc Qty

Loc Code

FP001

7

M130922

7

GA

261

m134360

112

m135135

149

OVER007

1200

m135530

600

m135767

600

ST303

671

m135407

128

m135600

543

16

DAS
6
9-89

OCT 1 8 2016

MS21209-F615

Purchased

No

110

Each

120.0000

1

58

MS21209-F615

Heli-Coil

**

Location

Loc Qty

Loc Code

GA

120

m135058

120

8

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Shop Packet Print

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DQA: _____ Date: _____

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
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								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
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